

Work Order ID 66109

February 7, 2011 7:32:25 AM



Page 1

Item ID: D3275-1

Accept



Setup Start



Revision ID:

Item Name: Crossbolt Spacer

Stop



Start Date: 2/07/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: CD Date: 11/02/07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3275 | Rev A1 | | | | | | | | |

100 Hardinge CNC LATHE SMALL 0.00



Hardinge Memo 0.00

Hardinge CNC Lathe Small 1-Turn as per Folio FA469 and Dwg D3275

SH 11/2/24

40 ✓

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC Memo 0.00

Quality Control

SH 11/2/24

40 ✓

120 QC8- Inspect parts - second check 0.00



QC Memo 0.00

Quality Control

SH 11.2.24

40 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location <u>LG</u> | 0.00 | | | | 40 | 0 | BE | 11/02/25 |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ***STOCK IN SKIDTUBE CELL*** | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 11/02/28 |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF

11-02-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 66109

Parent Item: D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 2/07/11

Required Date: 2/11/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 04.10.19 New issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6T0.3125W.05 8 | | Purchased | No | | | 100 | f | 18.0840 | 0.2666 | 11.22526 | | | |



ALUM TUBE .3125 x .058w



SA 11/2/24

Location

Loc Qty

Loc Code

MAT

18.084

116793

18.084

116793

11 PT

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NOTE: Date & initial all entries

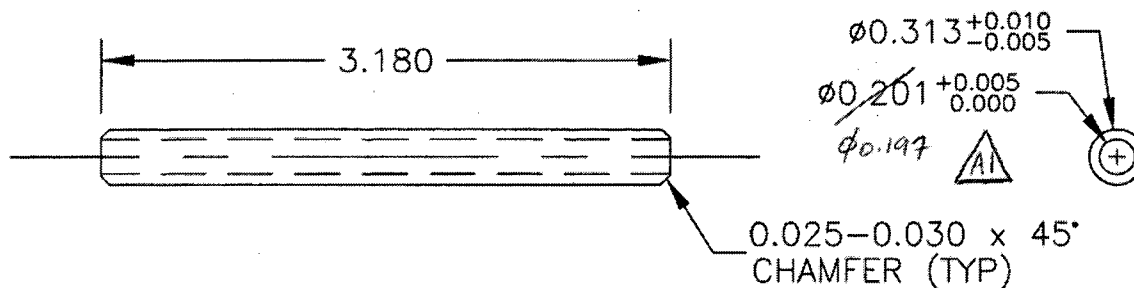


| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>AF</i> | APPROVED <i>AF</i> | DRAWING NO. D3275 | REV. A SHEET 1 OF 1 |
| DATE 04.03.10 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |
| A | 04.03.10 | NEW ISSUE | |
| AI | <i>CP</i> 04.10.19 | CHANGE MAT'L SPEC | |

RELEASED
04.06.22 *AF*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *666109*

0211/02107



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R) M6061T6T0.313W.058 *AI*
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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